



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB23006782
Job Sheet 180449



Part No: RB23006782

Job Qty: 1 ea

Part Name: Adapter, Torque Turbine Attach Lower Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB23006782 REV D IPP REV A 18.02.21 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/13/18	0.00	0.00	Start Up Small Fab-4		MLL
95	HandFinish	1 pcs		7/13/18	0.00	0.10	HandFinish7		SEB 18-07-11
100	Small Fab	1 pcs		7/13/18	0.00	1.00	Small Fab-9		MLL
110	QC	1 pcs		7/13/18	0.00	0.00	QC5		D 18-07-31
120	Large Fab	1 pcs		7/13/18	0.00	0.50	Large Fab 1		A
140	QC	1 pcs		7/13/18	0.00	0.00	QC9		D 18-08-01
152	Small Fab	1 pcs		7/13/18	0.00	0.00	Small Fab-1		MLL
154	QC	1 pcs		7/13/18	0.00	0.00	QC5		D 18-08-03
156	Outsource	1 pcs		7/13/18	0.00	0.00	Outsource13		ET 18-08-07
158	Packaging	1 pcs		7/13/18	0.00	0.00	Packaging2		ED AUG 09 2018
162	QC	1 pcs		7/13/18	0.00	0.00	QC6		38
210	Packaging	1 pcs		7/13/18	0.00	0.00	Packaging3-1		MLL 3-89
220	QC21-FG	1 Ea		7/13/18	0.00	0.00	QC21		21 AUG 13 2018

Part Op 95 - Bead blast remove all chrome on socket and wrench.

Descriptions: 100 - 1-HEAT and form wrench as per DWG using press. 2-Cut wrench as per DWG prior to welding.

120 - 1-Weld socket as per DWG using stainless rod

152 - 1- Buff welds and wrench using wire wheel 2- Engrave using Marktronic engraver as per NOTE on the DWG.

156 - -Issue P/O to Groupe Altech: P/O 40695 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color YELLOW -Certificate of Conformity is required

210 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
FS121	Snap-On Socket, Shallow, 3/8", 6-Point 23	1 Ea (1 ea)	90-Start up Operation	5082786
OEX120B	Wrench 21	1 Ea (1 ea)	90-Start up Operation	5082787

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	FS121	1	10	0
	OEX120B	1	10	0

Part Specifications

Specifications could not be found.

Plex 7/6/18 10:29 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

CONTROLLED DOCUMENT

APR 26 2016

JOB NUMBER
01-4885-A (4905 A)

CONTROLLED DOCUMENT

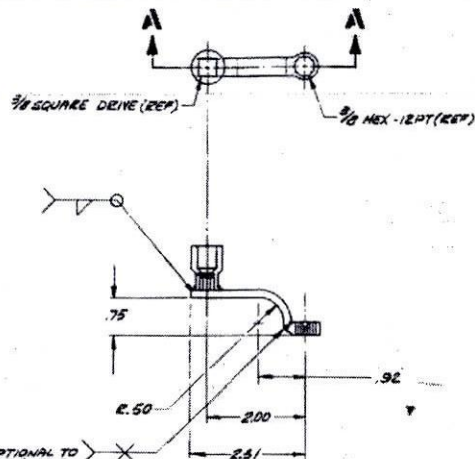
MAY 12 2015

JOB NUMBER
01-4697

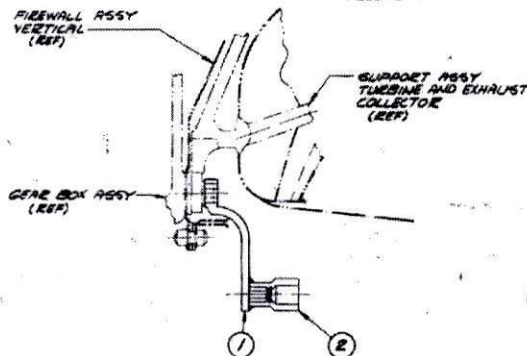
CONTROLLED DOCUMENT

JAN -4 2016

JOB NUMBER
01-4844-A



SECTION A-A
WELDMENT



CONTROLLED DOCUMENT

AUG 22 2016

JOB NUMBER
01-5094

STOP COPY
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RELEASED FOR PROD
DATE: 10/31/06 INT: 908

This data is furnished with the understanding that it will be used for Service, Maintenance and Overhaul purposes only and not for Manufacture or production of parts. The user is responsible for the accuracy of the data and shall not be held responsible for any errors or omissions. The user is also responsible for the accuracy of the data and shall not be held responsible for any errors or omissions. The user is also responsible for the accuracy of the data and shall not be held responsible for any errors or omissions.

SYMBOL	DESCRIPTION
1	FLATNESS
2	PERPENDICULARITY
3	PARALLELISM
4	CIRCULAR RUNOUT
5	ANGULAR RUNOUT
6	CHAMFER
7	DRILL
8	REVERSE
9	SPOT
10	WELD
11	WELD
12	WELD
13	WELD
14	WELD
15	WELD
16	WELD
17	WELD
18	WELD
19	WELD
20	WELD

BREAK SHARP EDGES .020 UDS

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6.55 101
1730 P 114
60EX 120B 1040
6.55 101 5/16-6pt
Head
3/8 Drive

Roll Page

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040695**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040695
PO Date: 8/7/18
Due Date: 8/14/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180449	RB23006782	Adapter, Torque Turbine Attach Lower Nut -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color YELLOW -Certificate of Conformity is required	Firmed	-	8/14/18	1 pcs	0 pcs	1 pcs	\$135.00/pcs	\$135.00

1 x AUG 09 2018

DA
38
9-89

Grand Total: \$135.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/8/18 12:36 PM dart.tsimiklis.chrisoula

CT.



Certificat de Conformité / Certificate of Compliance

(011616-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011616 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
09-Aug-2018		Aman		040695				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp. Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB23006782 Rev.	RB23006782 STRIP 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC MIN-CHG	1	1	0	0	0

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 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.